

5/02

<b>DART AEROSPACE LTD.</b>	<b>Work Order:</b>	<b>22083</b>
<b>Description:</b> Saddle Fitting, Fwd (Outboard/Inboard)	<b>Part Number:</b>	<b>D2571/D2572</b>
<b>Drawing:</b> D2571 Rev. D/D2572 Rev. D	<b>Qty:</b>	<b>10 5</b>
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	EP	04.12.08	10
2	MV	Make from D6101-007 billet for D2571 <b>Ensure that grain is along 7.75" length</b> Batch No: B20984	EP	04/12/13	5
3	MV	Make from D6101-005 billet for D2572 <b>Ensure that grain is along 5.00" length</b> Batch No: B21801	EP	04/12/13	5
4	MV	Fixturing W/O No. <u>N/A</u> Fixturing Inspection last completed 04/12/13 by EP	EP	04/12/13	5
5	MV	Program Batch No. B22083 Double check by: <u>ML</u>	EP	04/12/13	5
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/12/14	5
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/12/14	5
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/12/14	5
9	MV	Machine keyway as per dwg D2571 & D2572	EP	04/12/14	5
10	MV	Deburr and remove all machining marks	EP	04/12/14	5
11	MV	Tumble for 20 minutes to remove sharp edges # 04.02.11	EP	04/12/15	5
12	QC1	Inspect all dimensions to dimension sheets	EP	04/12/15	5
13	QC7	Second inspection	ML	04/12/16	5
14	FP	Acid etch and alodine as per QSI 005 4.1	ML	04-12-16	5
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	ML	05-01-03	5
16	QC3	Inspect Powder Coat	ML	05-01-03	5
17	ST	Identify and Stock.	ML	05-01-08	5
18	AC	Cost / Part <u>111.10</u> <u>103.07</u>	54C	05-01-09	5
19	DC	Close W/O <u>112.51</u> <u>99.53</u> Inspection Level 21	EP	05.01.06	5

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED  
02/10/15 RF